

What is claimed is;

1. A disc cartridge comprising a disc type recording medium housed for rotation in a flat housing which comprises a pair of metal shell halves and is provided with an opening
5 for giving a recording/reproducing head of a disc driver access to the disc type recording medium, wherein

at least one of the metal shell halves is provided along its periphery with an erected wall which is formed by bending a part of the edge of the shell half and is bonded to the other
10 shell half and an angle keeping means which keeps the bending angle of the erected wall at a predetermined angle is formed on the shell half integrally therewith.

2. A disc cartridge as defined in Claim 1 in which the angle keeping means is a groove which is V-shaped in
15 cross-section and formed along the inner side of the erected wall.

3. A disc cartridge as defined in Claim 2 in which the angle keeping means is a triangular rib which is embossed on the inner side of the erected wall substantially in
20 perpendicular thereto.

4. A disc cartridge comprising a disc type recording medium housed for rotation in a flat housing which comprises a pair of metal shell halves and is provided with an opening for giving a recording/reproducing head of a disc driver access
25 to the disc type recording medium, and a shutter for opening and closing the opening, wherein the shutter is formed by a

pair of metal shutter halves, at least one of the shutter halves is provided along its periphery with an erected wall which is formed by bending a part of the edge of the shutter half and is bonded to the other shutter half and an angle keeping means
5 which keeps the bending angle of the erected wall at a predetermined angle is formed on the shutter half integrally therewith.

5. A disc cartridge as defined in Claim 4 in which the angle keeping means is a groove which is V-shaped in
10 cross-section and formed along the inner side of the erected wall.

6. A disc cartridge as defined in Claim 4 in which the angle keeping means is a triangular rib which is embossed on the inner side of the erected wall substantially in
15 perpendicular thereto.

7. A method of producing a disc cartridge comprising a disc type recording medium housed for rotation in a flat housing which comprises a pair of metal shell halves and is provided with an opening for giving a recording/reproducing
20 head of a disc driver access to the disc type recording medium, wherein the improvement comprises that when forming an erected wall, which is bonded to the other shell half, on at least one of the shell halves by bending a part of the edge of the shell half, both the sides of the shell half are held under a pressure
25 by a jig, along the part along which the shell half is bent to form the erected wall, so that the sides are not pulled toward

the erected wall to be deformed upon bending the shell half.

8. A method as defined in Claim 7 in which the jig comprises a bending punch having a protrusion which extends along the erected wall and presses a side of the shell half adjacent to the inner side of the erected wall and a flat surface
5 which is substantially flush with the side of the shell half, and a bearer which is positioned on the side of the shell half opposite to the bending punch.

9. A method of producing a disc cartridge comprising
10 a disc type recording medium housed for rotation in a flat housing which comprises a pair of metal shell halves and is provided with an opening for giving a recording/reproducing head of a disc driver access to the disc type recording medium, and a shutter for opening and closing the opening, wherein the
15 improvement comprises that the shutter is formed by a pair of metal shutter halves, and when forming an erected wall, which is bonded to the other shutter half, on at least one of the shutter halves by bending a part of the edge of the shutter half, both the sides of the shutter half are held under a
20 pressure by a jig, along the part along which the shutter half is bent to form the erected wall, so that the sides are not pulled toward the erected wall to be deformed upon bending the shutter half.

10. A method as defined in Claim 9 in which the jig
25 comprises a bending punch having a protrusion which extends along the erected wall and presses a side of the shutter half

adjacent to the inner side of the erected wall and a flat surface which is substantially flush with the side of the shutter half, and a bearer which is positioned on the side of the shutter half opposite to the bending punch.

5 11. A method of producing a disc cartridge comprising a disc type recording medium housed for rotation in a flat housing which comprises a pair of metal shell halves and is provided with an opening for giving a recording/reproducing head of a disc driver access to the disc type recording medium,
10 and a rotary shutter which is for opening and closing the opening and is formed by a pair of shutter halves, wherein the improvement comprises that when a cylindrical projection is formed on one of the housing and the rotary shutter and a free end portion of the cylindrical projection is caulked with the
15 other of the housing and the rotary shutter engaged for rotation with the cylindrical projection, thereby forming a flange for preventing disengagement of said the other of the housing and the rotary shutter from the cylindrical projection, a groove which is V-shaped in cross-section and extends in a
20 circumferential direction of the cylindrical projection is formed on the peripheral surface of the cylindrical projection at the base of the flange prior to the caulking.

 12. A method as defined in Claim 11 in which the cylindrical projection is formed by barring.